

A2AP

Dart Aerospace Ltd.

Date: Wednesday, 24/09/2008 12:48:11 PM  
 User: Julie Lecocq

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : TAIL LIGHT FAIRING
Job Number : 42273	
Estimate Number : 12418	
P.O. Number :	Part Number : D3484042
This Issue : 24/09/2008 S.O. No. :	Drawing Number : D3484 REV E
Prsht Rev. : NC	Project Number : N/A
First Issue : // Type : LARGE FAB ASSY	Drawing Revision : E
Previous Run : 34463	Material :
Written By :	Due Date : 05/10/2008 Qty: 1 Um: Each
Checked & Approved By : <u>JUD 08.9.24</u>	
Comment : Est Rev:A New Issue 06-05-23 EC Est Rev:B 08-01-24 change rivet for CR1122-3-025 DD verified by:EC	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D34842	Base, RH
-----	--------	----------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
 BASE, RH  
 Batch: B34457-1 ✓

Pl 08.09.26

2.0	D34844	Face, RH
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
 FACE, RH  
 Batch: B34459 ✓

Pl 08.09.26

3.0	D34846	Cone, RH
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
 CONE, RH  
 Batch: B36403-1 \*

Pl 08.09.26

4.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

1-Weld as per Dwg D3484 using DT8880 Jig  
 A/R # AL ROD Batch: M108436

2-Buff & Smooth Welds to mating surfaces

Pl 08.09.26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Wednesday, 24/09/2008 12:48:11 PM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TAIL LIGHT FAIRING

Job Number: 42273

Part Number: D3484042

Job Number:



Seq. #: Machine Or Operation: Description :

5.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 08-09-26

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/09/26 (e)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M-h 08/09/26

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FF 08/09/29

9.0

CR1122 3 025

RIVET



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Rivet

Batch: M106878

FF 08/09/29

10.0

MS2106904

ANCHOR NUT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

ANCHOR NUT

Batch: M103693

FF 08/09/29

11.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Install Nut Plates as per Dwg D3484

FF 08/09/29

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/09/26 (e)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Wednesday, 24/09/2008 12:48:12 PM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TAIL LIGHT FAIRING

Job Number: 42273

Part Number: D3484042

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

POWDER COATING

POWDER COATING



M109152



(IX)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

8:50  
320  
9:20

M-A 08/09/29

14.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



JS



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-09-29

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

Identify on inside surface as indicated

TCCA-PDA, DART AEROSPACE LTD

P/N: D412-750-142 B/N: BXXXXX

FOR PRODUCT ELIGIBILITY SEE PDA06-13

PPP 42241 P 08/29

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/09/29 (SIRN)

17.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

D 08/09/29

Job Completion



Mf 08-09-29

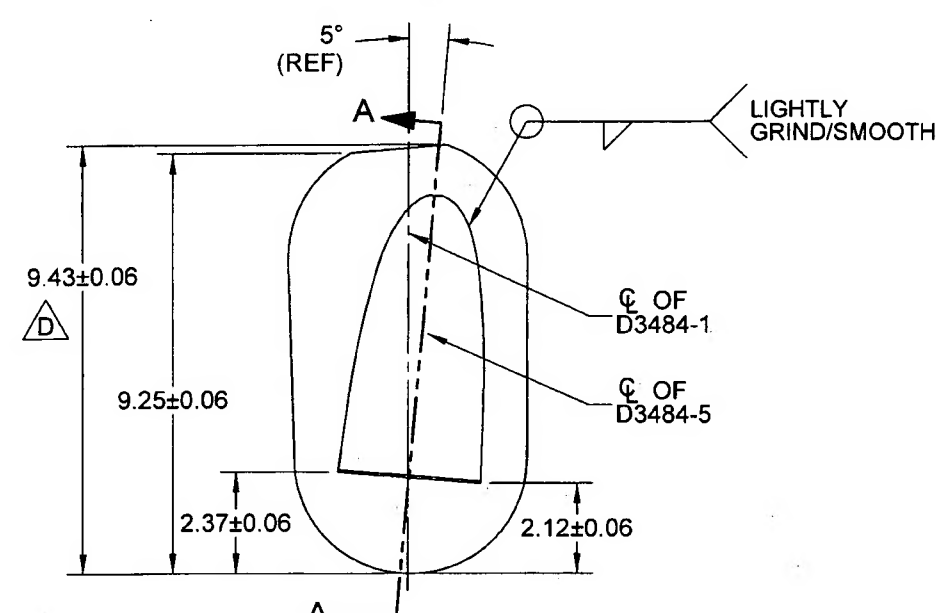
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

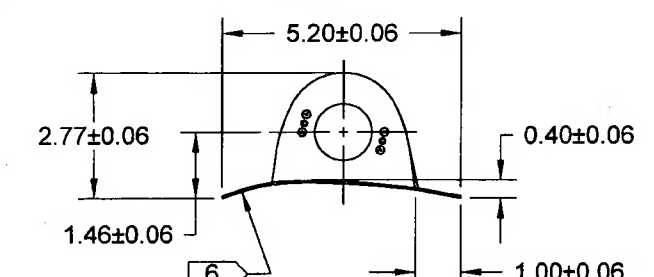
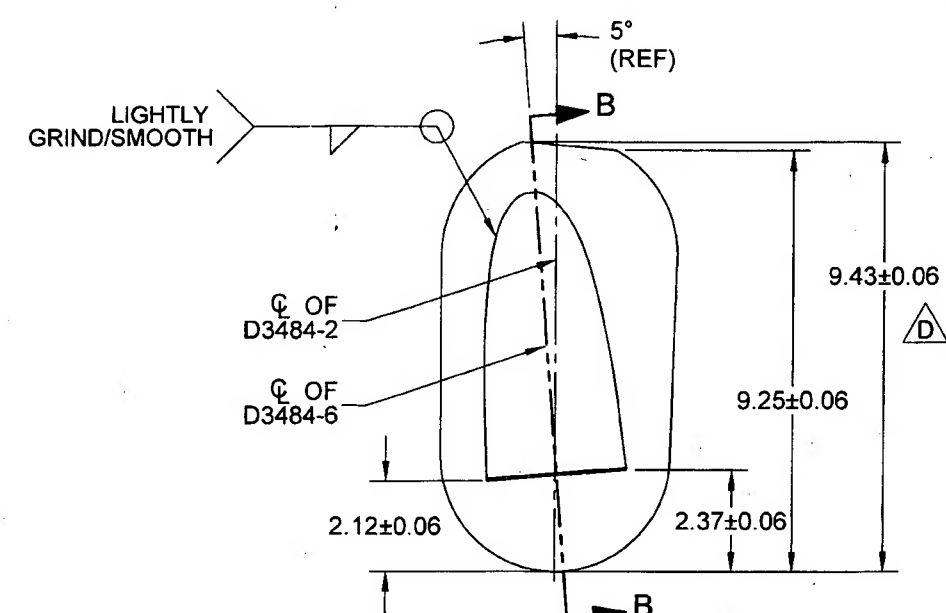
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

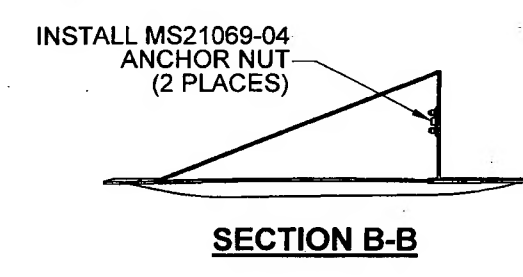
**NOTE:** Date & initial all entries



QTY -041	QTY -042	P/N	DESCRIPTION
X		D3484-041	TAIL LIGHT FAIRING ASSEMBLY (LH)
	X	D3484-042	TAIL LIGHT FAIRING ASSEMBLY (RH)
1		D3484-1	BASE (LH)
	1	D3484-2	BASE (RH)
1		D3484-3	FACE (LH)
	1	D3484-4	FACE (RH)
1		D3484-5	CONE (LH)
	1	D3484-6	CONE (RH)
4	4	CR1122-3-02.5	RIVET
2	2	MS21069-04	ANCHOR NUT



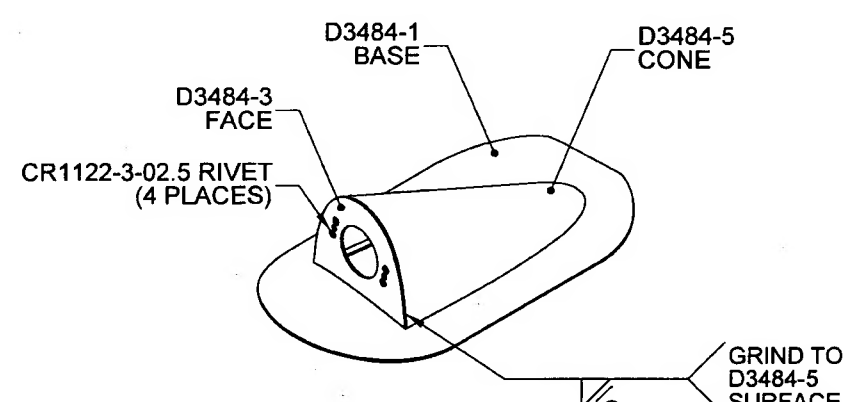
SECTION A-A



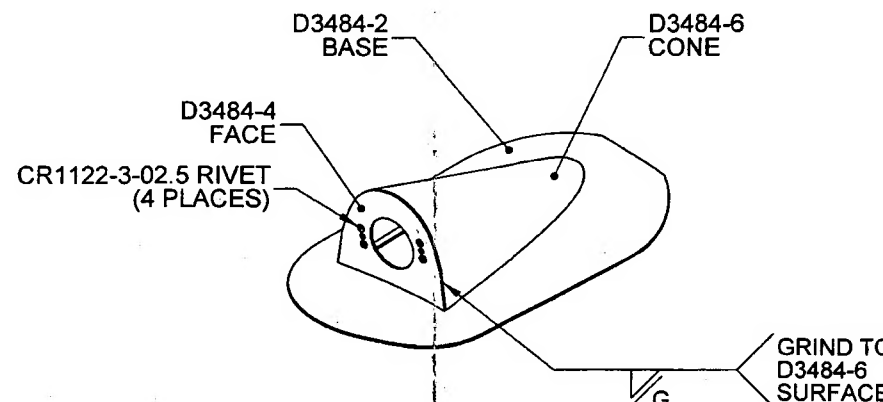
SECTION B-B

D3484-041 TAIL LIGHT FAIRING

D3484-042 TAIL LIGHT FAIRING



D3484-041 ISOMETRIC VIEW



D3484-042 ISOMETRIC VIEW

- NOTES:
- 1) MATERIAL: N/A
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) WELDING: PER DART QSI 004
  - 6) IDENTIFICATION: IDENTIFY ON INSIDE SURFACE AS INDICATED WITH WHITE LABEL:  
"TCCA-PDA, DART AEROSPACE LTD., P/N D412-750-141/-142 B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA06-13"
  - 7) WEIGHT: 0.30 lbs

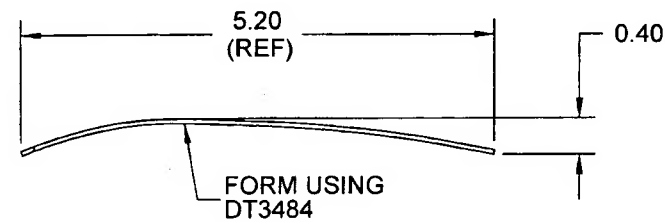
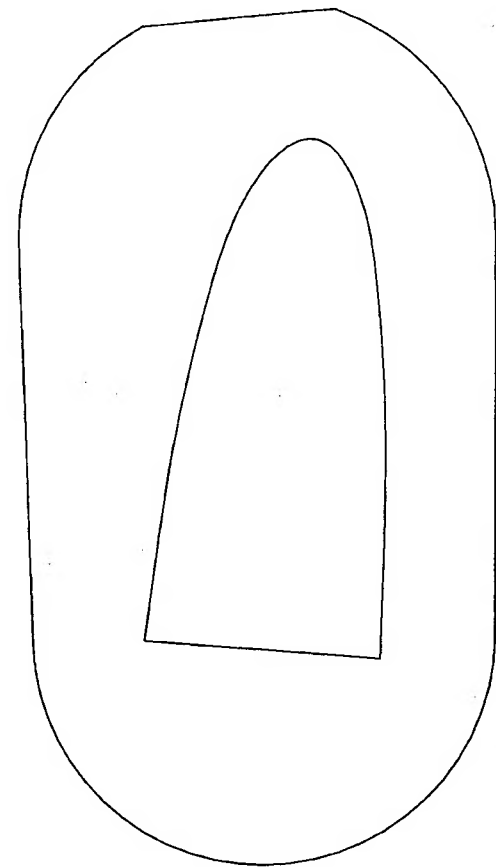
REV.	DESCRIPTION	BY	DATE
E	REDRAWN/REFORMAT TO SHOW LH AND RH CONFIGURATIONS FOR CLARITY; CORRECT VIEWS ON SHEET 3 & 4 (WAS SHOWING MIRROR IMAGE OF PARTS); DIM 1.560 WAS 1.563 (SHEET 3, ZONE B4); CR1122-3-02.5 RIVET WAS MS20426AD3-3 RIVET	MB	08.01.03
D	CORRECT D3484-1F	MB	06.06.22
C	RE-DESIGN D3484-3F/-5F	MB	06.04.20
B	RE-DESIGN	MB	06.02.21
A	NEW ISSUE	MB	05.11.29

DESIGN	DATE	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA DRAWING NO. <b>D3484</b> TITLE <b>TAIL LIGHT FAIRING</b> SCALE <b>1:4</b> <small>COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>
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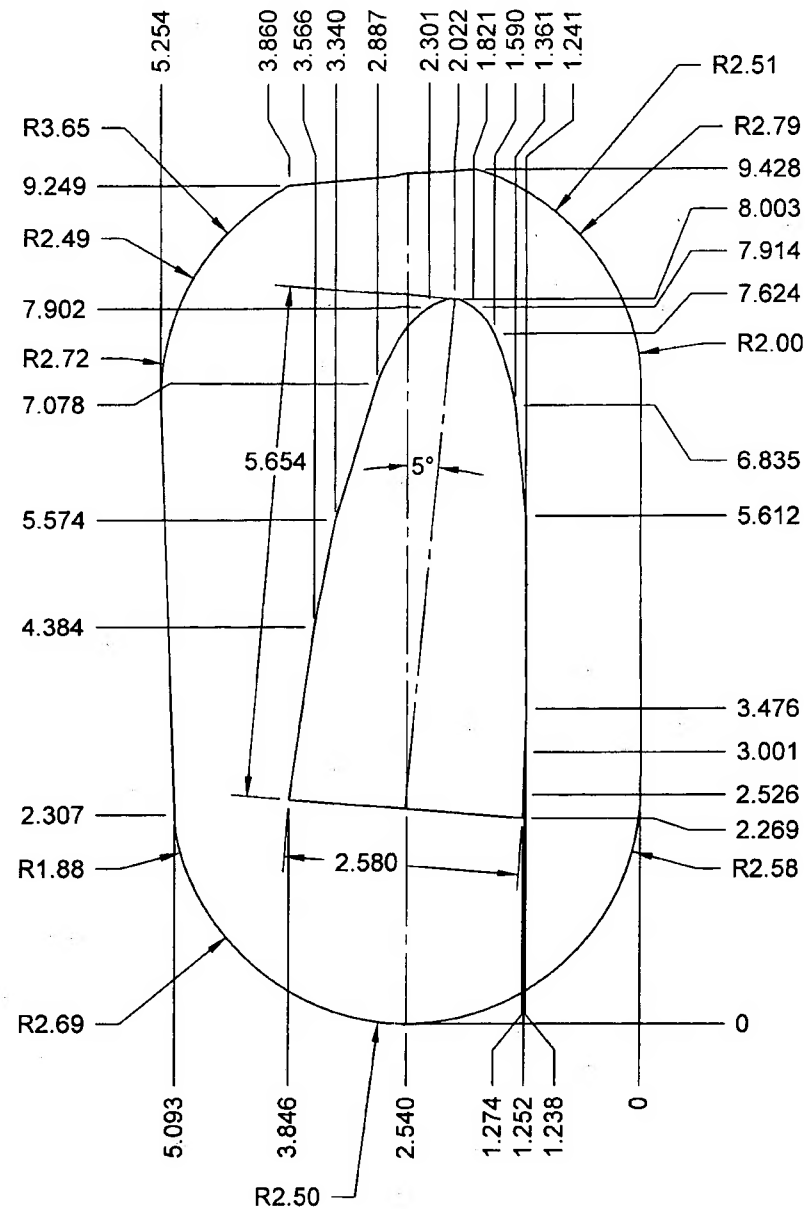
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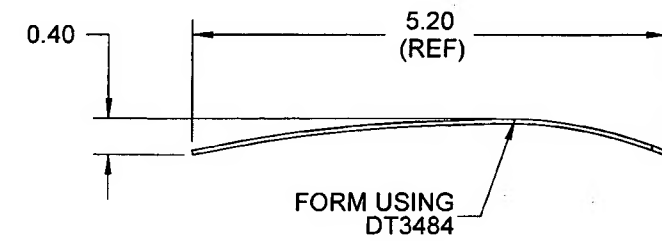
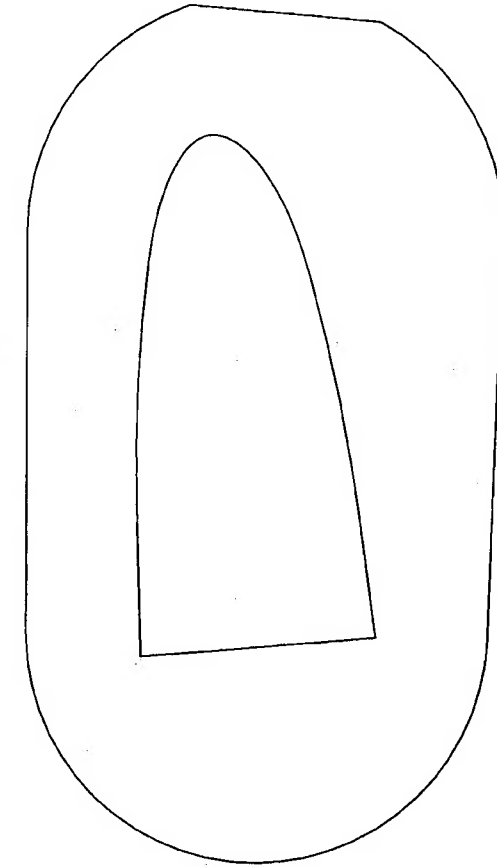
**D3484-1 BASE**  
(MAKE FROM D3484-1F)

**NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET (0.050 THICK)  
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027  
(REF. DART SPEC. M6061T6S.050)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.16 lbs



**D3484-1F BASE FLAT PATTERN**

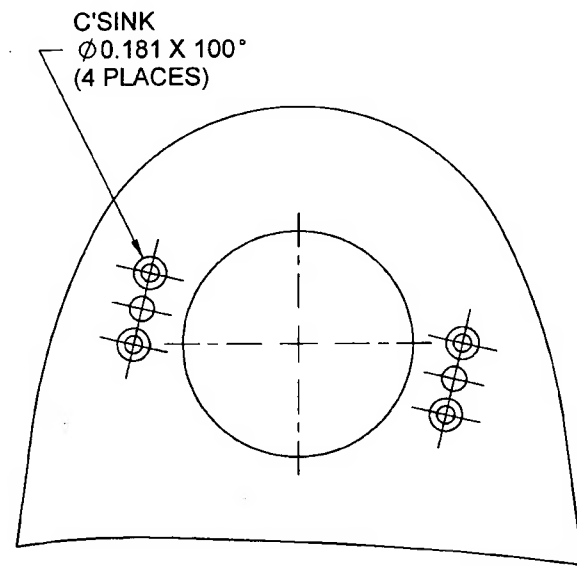


**D3484-2 BASE**  
(MAKE FROM D3484-1F)

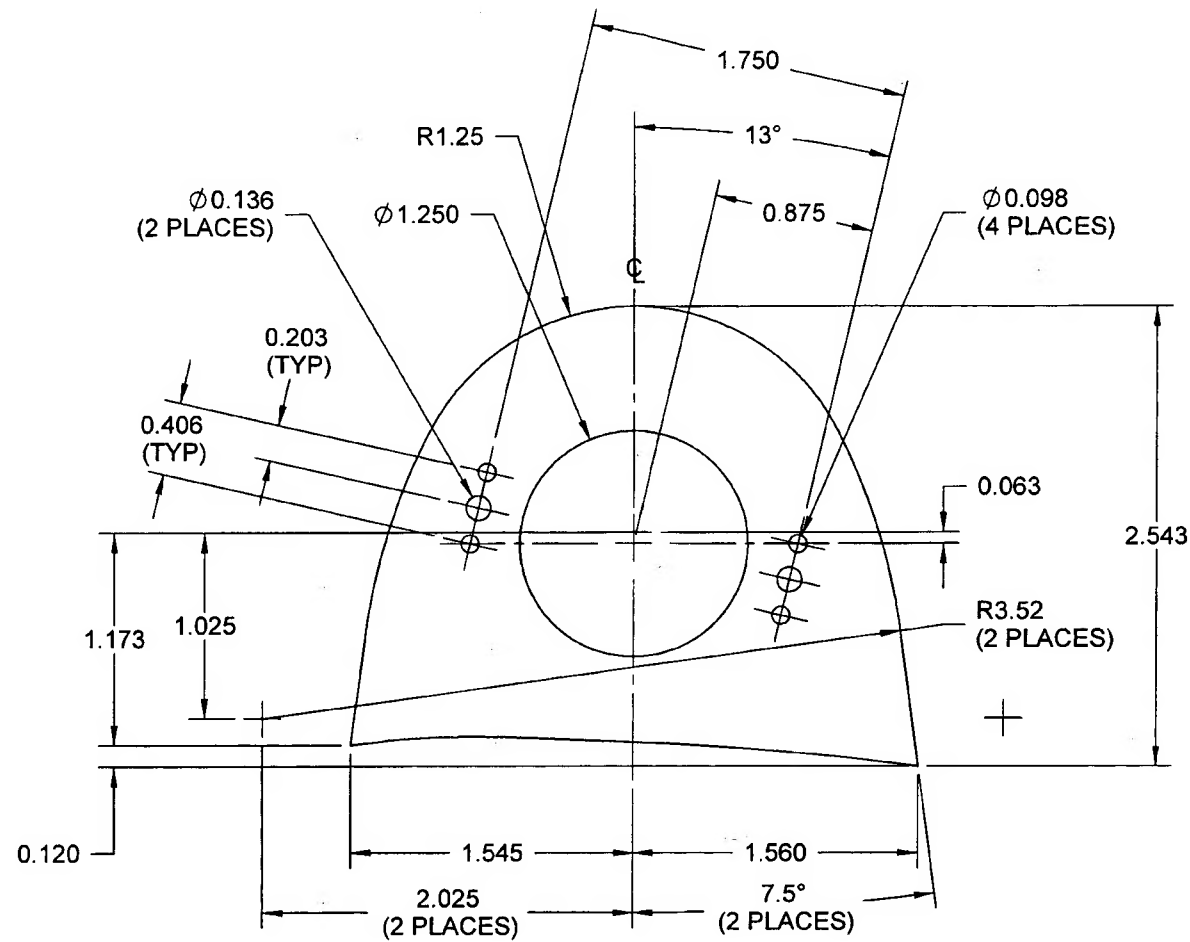
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MFG. APPR.		D3484	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		<b>TAIL LIGHT FAIRING</b>	1:2
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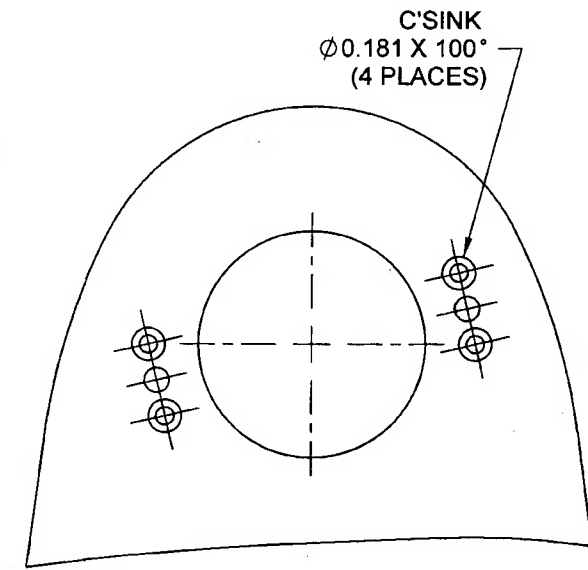




**D3484-3 FACE**  
(MAKE FROM D3484-3F)



**D3484-3F FLAT PATTERN TAIL LIGHT FAIRING**



**D3484-4 FACE**  
(MAKE FROM D3484-3F)

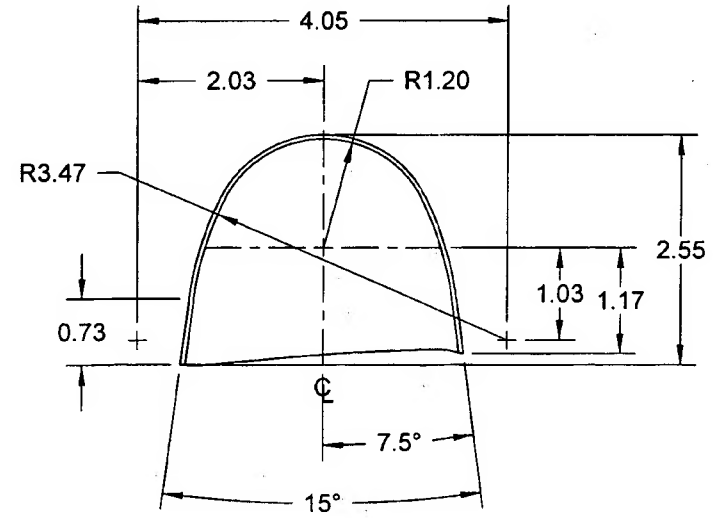
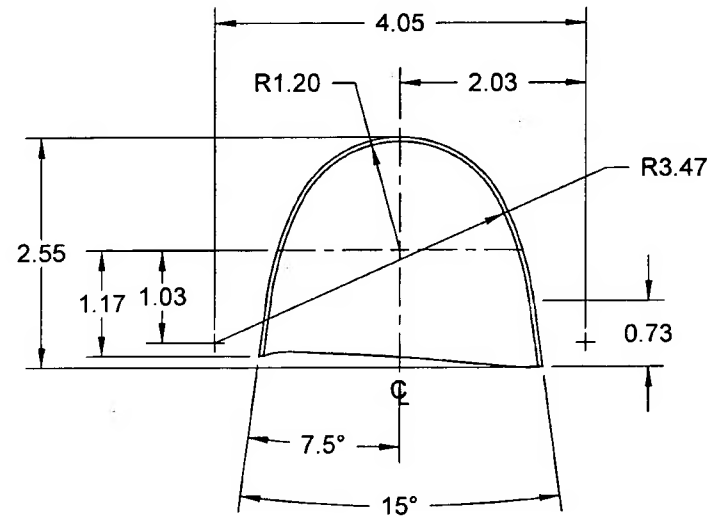
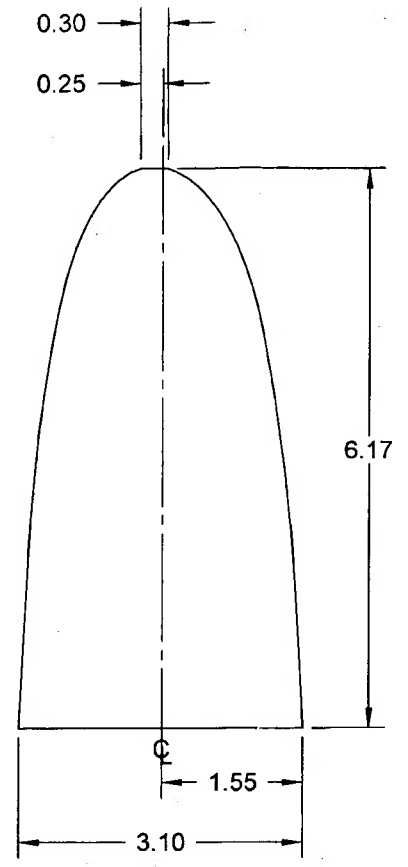
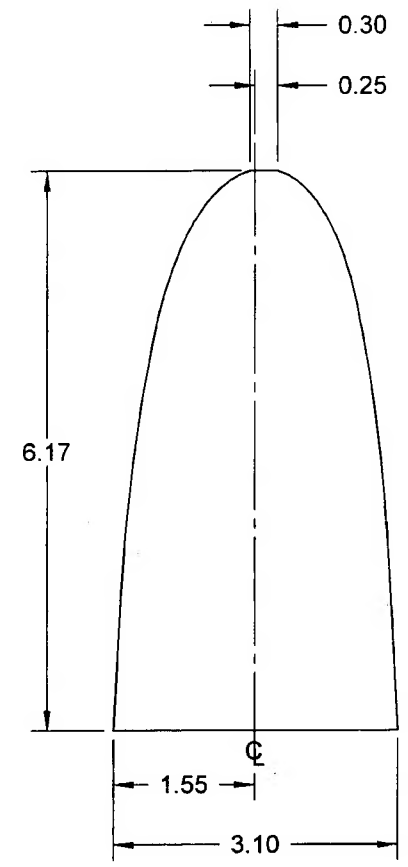
- NOTES:**
- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET (0.050 THICK)  
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027  
(REF. DART SPEC. M6061T6S.050)
  - 2) FINISH: N/A
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 0.02 lbs

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MFG. APPR.		D3484	SHEET 3 OF 4
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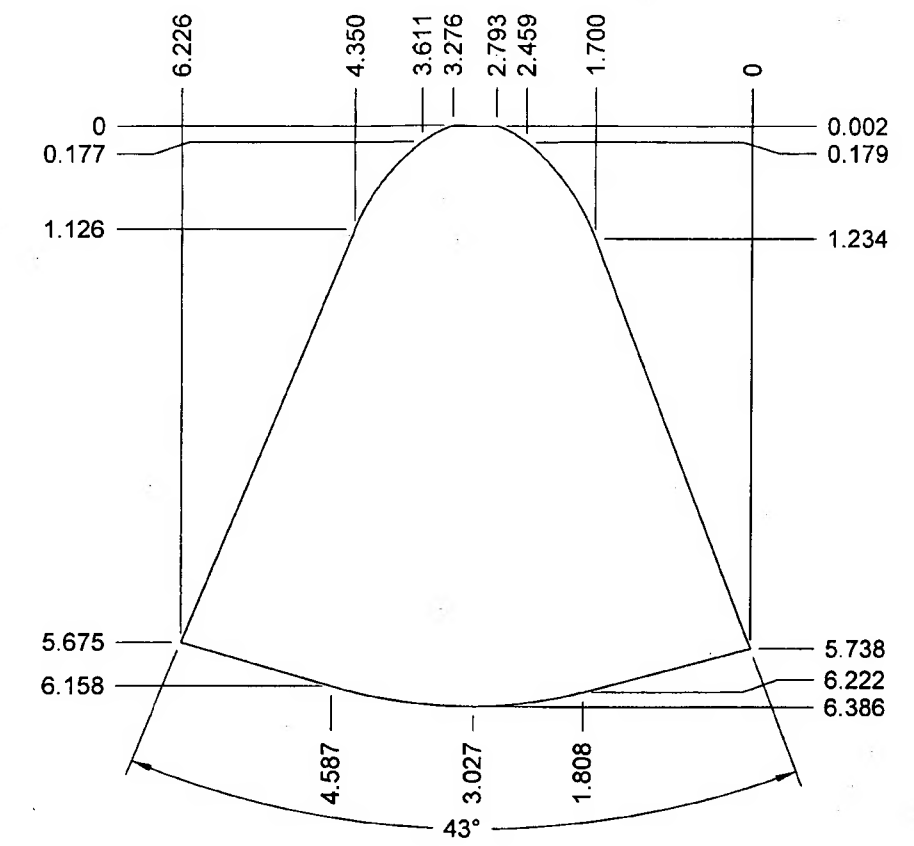
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08.01.17/11/02

8 7 6 5 4 3 2 1



**D3484-5 CONE**  
(MAKE FROM D3484-5F)

**D3484-6 CONE**  
(MAKE FROM D3484-5F)



**D3484-5F CONE FLAT PATTERN**

- NOTES:**
- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET (0.050 THICK)  
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027  
(REF. DART SPEC. M6061T6S.050)
  - 2) FINISH: N/A
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 0.11 lbs

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MFG. APPR.		<b>D3484</b>	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		<b>TAIL LIGHT FAIRING</b>	1:2
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8 7 6 5 4 3 2 1